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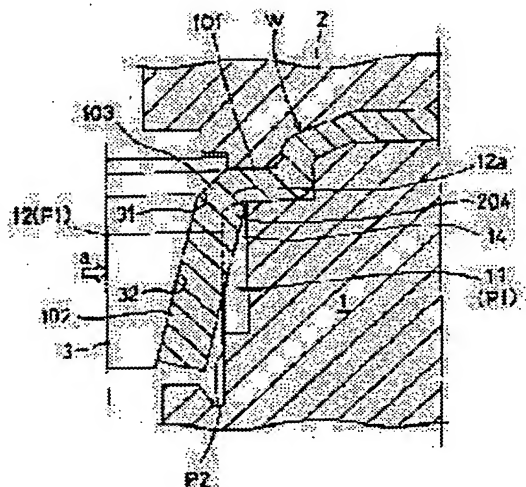
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(54) METHOD FOR FORMING INTERNAL GEAR MADE OF SHEET METAL AND INTERNAL GEAR MADE OF SHEET METAL

(57)Abstract:

PROBLEM TO BE SOLVED: To provide a forming method of an internal gear made of sheet metal through the form rolling in which the reliability on the mechanical strength is improved by increasing the wall thickness of a continuous part between a base plate part and a circumferential wall part and the wall thickness of the continuous part between the base plate part and the circumferential wall part can be increased in the internal gear made of sheet metal capable of being used as a viscous coupling cover having the base plate part and the circumferential wall.

SOLUTION: A continuous part 103 between a base plate part 101 and a circumferential wall 102 of a cup-shaped work W is pressed, at the prescribed position by a forming roller 3 while the cup-shaped work W fitted to a rotary inner die 1 is rotated together with the rotary inner die 1. A recessed formed space 11 is filled with the material of the continuous part 103 to form a root part of a mountain part of the internal gear into a shape having no underfill. At the same time, a tapered wall surface is formed on a valley part of the internal gear. Then, the circumferential wall 102 is pressed toward the rotary inner die 1 to form the rest of the mountain and valley parts.



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